

# Work Order ID 47633-1

October 7, 2009 10:48:25 AM



Page 1

Item ID: D5957

Accept



Setup Start



Revision ID: B

Item Name: Saddle, 205

Stop



Start Date: 10/07/09 Start Qty: 5.00



Cust Item ID:

Required Date: 10/07/09 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D5957

Rev B

100

0.00



✓ HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per folio D5957, Ensure Batch Number is entered  
2-Machine Keyway 3-Deburr & Tumble

110

0.00



✓ QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

120

0.00



✓ QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*See attached  
COES  
w/o*

# Work Order ID 47633-1

October 7, 2009 10:48:26 AM



Page 2

Item ID: D5957

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle, 205

Start Date: 10/07/09 Start Qty: 5.00



Cust Item ID:

Required Date: 10/07/09 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



HandFinish

Hand Finishing

✓ Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

140



Powdercoat

Powder Coating

✓ White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

150



QC

Quality Control

✓ QC3- Inspect Part Finish

0.00

Memo

0.00

# Work Order ID 47633-1

October 7, 2009 10:48:26 AM

Page 3

Item ID: D5957  
Revision ID: B  
Item Name: Saddle, 205

Accept

Setup Start

Stop

Start Date: 10/07/09 Start Qty: 5.00  
Required Date: 10/07/09 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:  
QC:

Date:

Tooling:

Date:

Run Start

Stop

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

✓ Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/07  
W. G. 10/07

# Picklist Print

October 7, 2009 10:48:24 AM

Page 1

Work Order ID: 47633-1



Parent Item: D5957RevB



Parent Item Name: Saddle, 205

Start Date: 10/07/09

Required Date: 10/07/09

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007RevB		Manufactured	No			110	Each	0.0000	5.0000			
Saddle Billet												

June 26, 2009 11:47:53 AM

Page 1

Item ID: ~~D3041~~ 5

**Accept**

Revision ID: C

**Setup Start**

**Item Name:** Clamp

**Stop**

**Start Date:** 15/07/2009      **Start Qty:** 20.00

**Cust Item ID:**

**Required Date:** 03/08/2009      **Req'd Qty:** 20.00

**Customer:**

**Reference:**

Run Start

**Approvals:**

### Process Plan:

**Date:**

### Tooling:

Date:

**Stop**

**QC:**

Date:

**SPC (Y/N):**

**Date:**

[illegible]

[illegible]

June 26, 2009 11:47:53 AM

[illegible]

\_\_\_\_\_

**THE UNIVERSITY OF CHICAGO**

**Customer:**



**Author's address:** Department of Psychology, University of California, San Diego, La Jolla, CA 92037, USA.  
E-mail: [benjamin@ucsd.edu](mailto:benjamin@ucsd.edu)

**00000000000000000000000000000000**

[illegible]

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

0.00

[illegible]

0.00

## Quality Control

0.00

[illegible]

0.00

## Hand Finishing

0.00

[illegible]

0.00

## Powder Coating

START TIME: \_\_\_\_\_ OVEN TEMPERATURE: \_\_\_\_\_  
FINISH TIME: \_\_\_\_\_

# Work Order ID 47633

June 26, 2009 11:47:53 AM

Page 3

Item ID: D3041-5

Accept

Revision ID: C

Item Name: Clamp

Setup Start

Stop

Start Date: 15/07/2009 Start Qty: 20.00

Required Date: 03/08/2009 Req'd Qty: 20.00

Cust Item ID:

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
170  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00  0.00							
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

## Picklist Print

June 26, 2009 11:33:17 AM

Page 1

**Work Order ID:** 47633



**Parent Item:** D3041-5RevC



**Parent Item Name:** Clamp

**Start Date:** 15/07/2009

**Required Date:** 03/08/2009

**Comments:**

**Start Qty: 20.00**

**Required Qty: 20.00**

[illegible]



Date: Wednesday, 29/04/2009 3:07:51 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: INNER AFT SADDLE
Job Number	: 47633-2		
Estimate Number	: 11082		
P.O. Number	:	Part Number	: D5957
This Issue	: 29/04/2009 S.O. No. :	Drawing Number	: D5957 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 43248	Material	:
Written By	:	Due Date	: 15/05/2009
Checked & Approved By	: <u>TUD 09.04.29</u>	Qty:	<u>split 5</u> Um: Each
Comment	: Est Rev:E Re-Format 05-11-29 JLM Est Rev:F ecn826 06.12.06 ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6101007	Saddle Billet
-----	----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)  
 D6101-007(7075-T7351)  
 Size 2.50" x 7.50" X 8.25" (Grain along 7.50")  
 Batch: 46412

SL 09/06/24

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5957, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr &amp; Tumble

SL 09/06/29

(5)

(PTO)

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

SL 09/06/29

(5)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

DT 09/06/30

(5)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

SL 09-06-30

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D5957 PAR #: \_\_\_\_\_ Fault Category: Machined parts NCR: Yes No DQA: / Date: 05.10.14  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 05.10.14

NCR: <u>47633-1</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.06.29	2.1	1 saddle scrap. Saddle was positioned wrong in the machine. The clavel pins in the sig were put in the wrong holes, causing a 0.85" deep machine mark, 0.250 wide x 1.2" long, 1.6" up from the bottom of the saddle.	<u>/</u> RS1412	Scrap i. destroy the part Replace Qty 1 B <u>46412</u> Ensure to verify prior to machining	<u>/</u> 05/06/29	<u>/</u> 09/10/13	<u>/</u> RS1412	<u>/</u> 09/06/29
		+ Folio etc. is clean. + Employee positioned it wrong  R.C. Operator error L.O.A.	<u>/</u> RS1412	<u>/</u>			<u>/</u> RS1412	<u>/</u> 09/06/29

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:07:51 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER AFT SADDLE

Job Number: 47633

Part Number: D5957

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M111472



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:50am

OVEN TEMPERATURE:

320°F

FINISH TIME:

12:20pm

all

09-06-30

(X5)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR

09-06-30

(5)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57430

09/6/30

(5)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	471033
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b>	D5957
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.321	.321	.321	.321		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.581		
K	0.315	0.322		.321	.321	.321	.321		
L	0.495	0.505		.498	.498	.498	.498		
M	0.490	0.510		.499	.499	.498	.498		
N	1.865	1.885		1.885	1.885	1.885	1.885		
O	7.990	8.010		8.001	8.001	8.001	8.001		
P	2.240	2.260		2.252	2.252	2.252	2.252		
Q	0.307	0.312		.311	.310	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.496	.495	.495	.496		
T	1.625	1.645		1.627	1.632	1.630	1.631		
U	2.000	2.020		2.000	2.005	2.005	2.004		
V	0.023	0.043		.03	.03	.03	.03		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

<b>Measured by:</b>	JL / SD	<b>Audited by:</b>	
<b>Date:</b>		<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.09.05	Dimension K revised	KJ/DD	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	47633
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b>	D5957
<b>Inspection Dwg:</b> D5957		<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.440					
B	1.745	1.755		1.748					
C	5.245	5.255		5.250					
D	6.995	7.005		7.000					
E	5.240	5.260		5.250					
F	4.745	4.755		4.750					
G	0.315	0.322		0.321					
H	1.522	1.532		1.527					
I	3.048	3.058		3.053					
J	4.575	4.585		4.580					
K	0.315	0.322		0.322					
L	0.495	0.505		0.500					
M	0.490	0.510		0.503					
N	1.865	1.885		1.885					
O	7.990	8.010		8.000					
P	2.240	2.260		2.252					
Q	0.307	0.312	313.	0.312					
R	0.760	0.765		0.760					
S	0.490	0.510		0.500					
T	1.625	1.645		1.630					
U	2.000	2.020		2.005					
V	0.023	0.043		0.030					
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

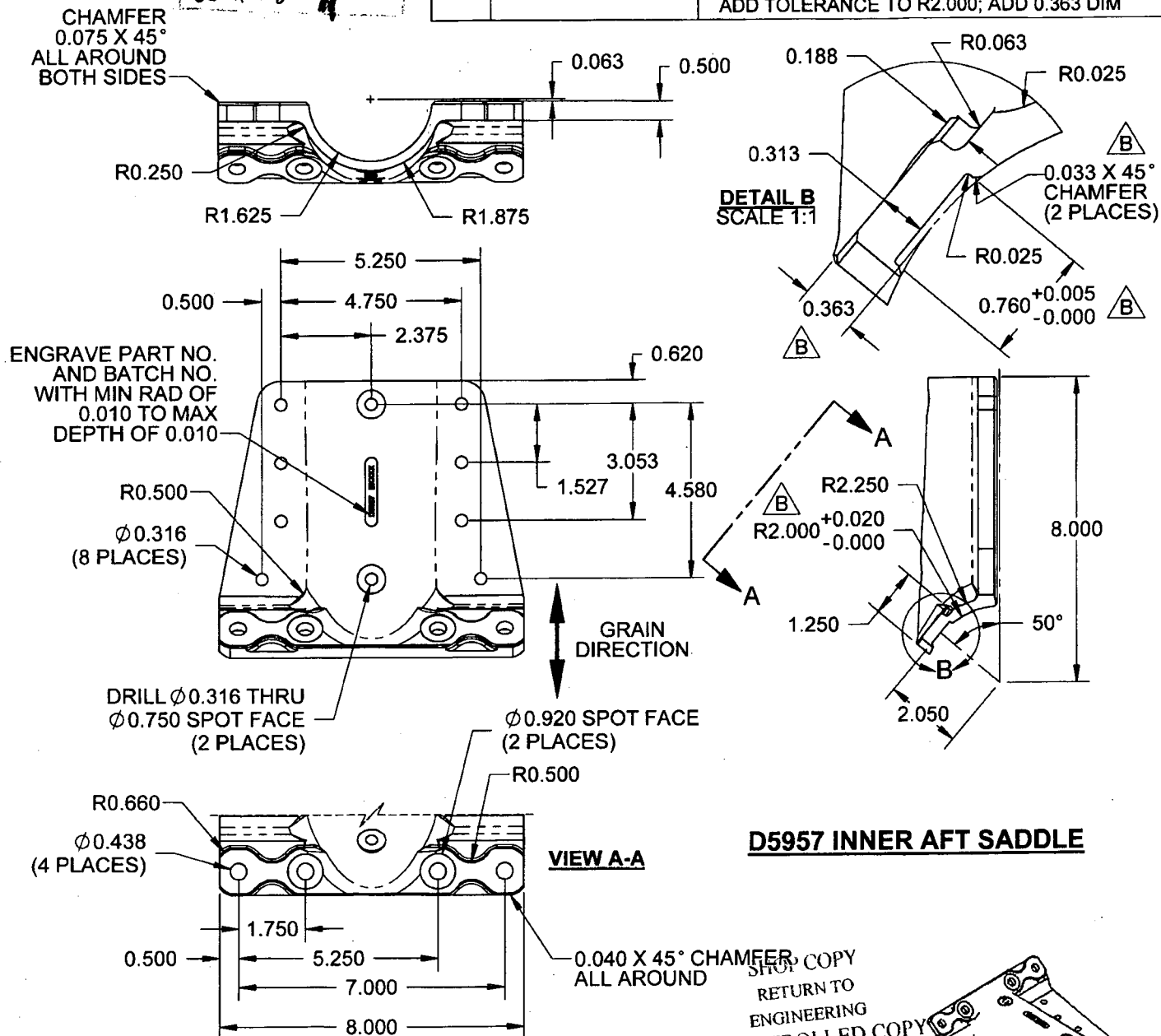
Measured by:	SD
Date:	09/06/29

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.09.05	Dimension K revised	KJ/DD	

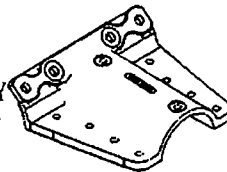
**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D5957</b>	REV. B SHEET 1 OF 1
DATE <b>06.11.07</b>	TITLE <b>INNER AFT SADDLE</b> SCALE 1:4		
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$ ; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

SHOT COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER



**ISOMETRIC VIEW**  
SCALE 1:8

COPYRIGHT © 1997 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

# Work Order Summary

October 7, 2009 10:46:06 AM

Page 1 of 2

Criteria : Work Order ID: 47633 Item ID: D3041-5RevC Product Family MACHINING  
 Work Order Start Dates 7/15/09 to 7/15/09 11:59:59 PM Work Order Required Dates 8/03/09 to 8/03/09  
 11:59:59 PM

All References  
 Work Order Status Released

Work Order ID 47633 Required Qty 20.0000 Status Code Released  
 Item ID D3041-5RevC Accepted Qty 0.0000 Scrap Qty 0.0000  
 Item Name Clamp  
 Current Acct Value \$4.574 Sales Order ID

Start Date 7/15/09 Required Date 8/03/09 Completed Date  
 Standard \*\* Actual \*\* \*\* Acct. Value \*\* \*\* Variance \*\* \*\* Variance % \*\*

Direct Costs	Total	Each	Each	Each	Each
Material	\$58.230	\$0.000	\$1.090	\$1.090	100.00%
Labor	\$434.569	\$0.000	\$1.250	\$1.250	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$1,170.895	\$0.000	\$2.830	\$2.830	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
<b>** Total **</b>	<b>\$1,663.694</b>	<b>\$0.000</b>	<b>\$5.170</b>	<b>\$5.170</b>	

Item ID/ Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
ZWIP	0.0000				
Opening WIP BALANCE MATERIAL COST			6/25/09	188.3500	\$188.350
			6/26/09	-130.1200	-\$130.120
			<b>Total Matl Amts:</b>		<b>\$58.230</b>

## Work Center

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
PARI01	7/01/09											
N/A			0.00	0.00	4.25	4.25	1.00	\$0.000	\$75.013	\$177.948	\$0.000	\$252.96
ZWIP	6/25/09											
N/A			0.00	0.00	332.56	332.56	1.00	\$0.000	\$332.560	\$964.424	\$0.000	\$1,296.98
	6/26/09											
N/A			0.00	0.00	8.86	8.86	1.00	\$0.000	\$8.856	\$0.000	\$0.000	\$8.85
<b>Total:</b>			0.00	0.00	345.67	345.67	3.00	\$0.000	\$416.429	\$1,142.372	\$0.000	\$1,558.80

## Work Center HandFinish

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
-------------	-------------	---------------	----------------	--------------------------	----------------	--------------------------	------------------	-----------------	-----------------	--------------------	--------------------	------------------

LAUG01

October 7, 2009 10:46:06 AM

Work Order Summary

Page 1 of 2



Date: Wednesday, 29/04/2009 3:07:51 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : INNER AFT SADDLE

Job Number : 47633-1

Estimate Number : 11082

P.O. Number :

Part Number : D5957

This Issue : 29/04/2009 S.O. No. :

Drawing Number : D5957 REVB

Prsht Rev. : NC

Project Number : N/A

First Issue : // Type : MACHINED PARTS

Drawing Revision : B

Previous Run : 43248

Material :

Due Date : 15/05/2009

Qty: *split 1* Um: Each

Written By :

Checked &amp; Approved By :

Comment : Est Rev:E Re-Format 05-11-29 JLM

Est Rev:F ecn826 06.12.06 ec

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101007

Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

D6101-007(7075-T7351)

Size 2.50" x 7.50" X 8.25" (Grain along 7.50")

Batch: *46412**JK 09/06/24*

2.0

HAAS3

HAAS CNC VERTICAL MACHINING #3



Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5957, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr &amp; Tumble

*JK 09/06/24*

3.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*JK 09/06/24*

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*DP 09/06/24*

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*JK 09-06-24 RV*

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER AFT SADDLE

Job Number: 47633

Part Number: D5957

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M111472



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

2:15pm

OVEN TEMPERATURE:

320°C

FINISH TIME:

2:45pm

09/06/24 (K1)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 430

9/6/24

SI

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09/06/24

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 471033
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b> D5957
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		439					
B	1.745	1.755		1.750					
C	5.245	5.255		5.250					
D	6.995	7.005		7.000					
E	5.240	5.260		5.250					
F	4.745	4.755		4.750					
G	0.315	0.322		321					
H	1.522	1.532		1.527					
I	3.048	3.058		3.053					
J	4.575	4.585		4.580					
K	0.315	0.322		321					
L	0.495	0.505		498					
M	0.490	0.510		499					
N	1.865	1.885		1.885					
O	7.990	8.010		8.001					
P	2.240	2.260		2.252					
Q	0.307	0.312		311					
R	0.760	0.765		760					
S	0.490	0.510		496					
T	1.625	1.645		1.627					
U	2.000	2.020		2.000					
V	0.023	0.043		033					
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

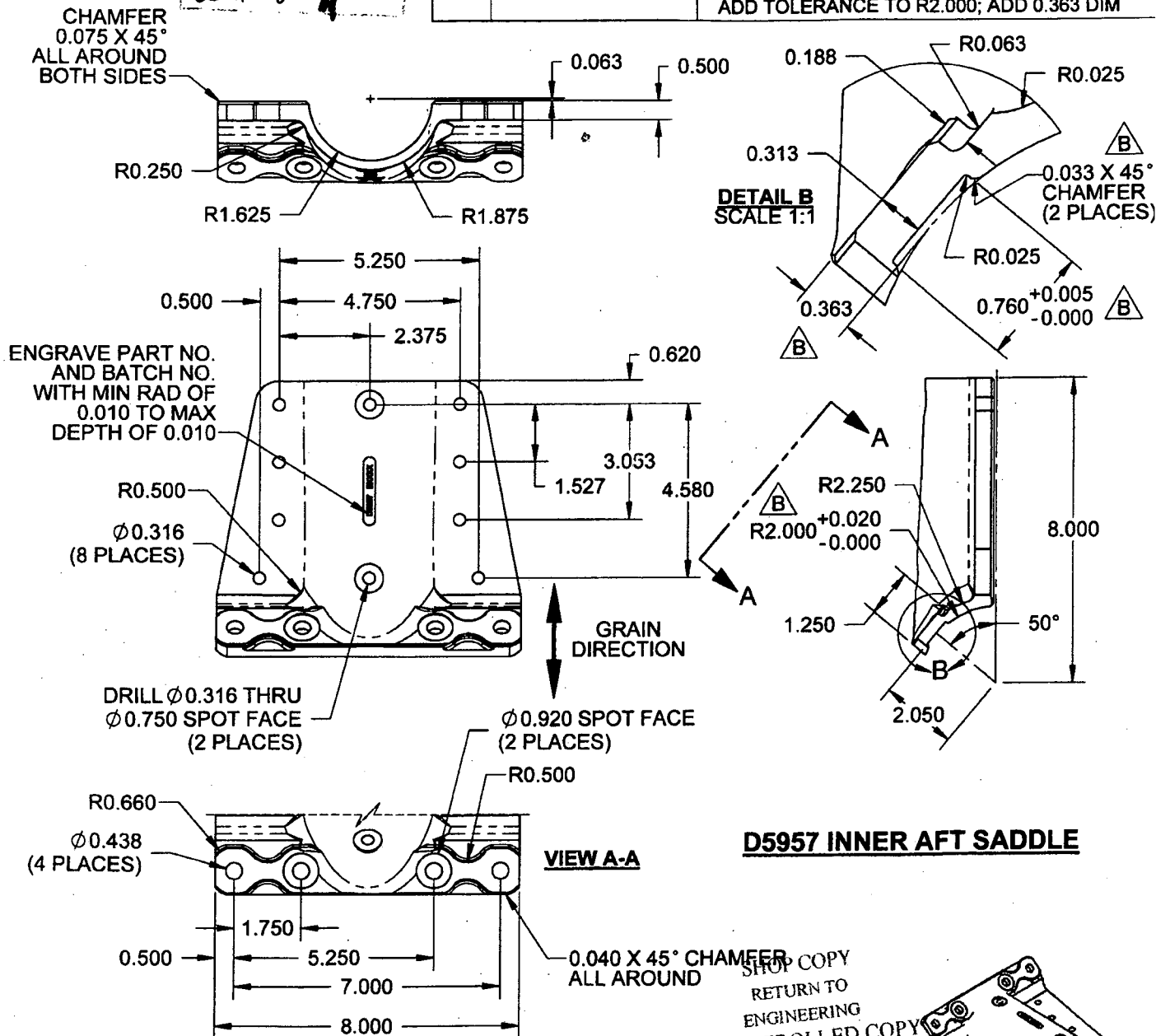
<b>Measured by:</b>	JL
<b>Date:</b>	

<b>Audited by:</b>	SP
<b>Date:</b>	09/06/24

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.09.05	Dimension K revised	KJ/DD	

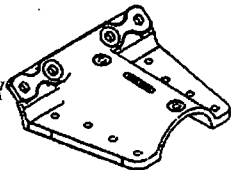
**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D5957</b>	REV. SHEET 1 OF
DATE <b>06.11.07</b>	TITLE <b>INNER AFT SADDLE</b>		
REV <b>A</b>	DATE <b>97.05.06</b>	DESCRIPTION <b>NEW ISSUE</b>	
<b>B</b>	<b>06.11.07</b>	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$ ; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12 (MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER



**ISOMETRIC VIEW**  
SCALE 1:8

COPYRIGHT © 1997 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.